Date: Wednesday, 03/09/2008 10:26:14 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number	: 41726		
Estimate Number	: 12931		
P.O. Number	:	**Part Number**	: D29332UP
This Issue	: 03/09/2008 **S.O. No.** :	**Drawing Number**	: D2933 REV C
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : MACHINED PARTS	**Drawing Revision**	: C
Previous Run	: 35280	**Material**	:
Written By	:	**Due Date**	: 26/09/2008 **Qty:** 2 **Um:** Each
Checked & Approved By	: JLD 08.9.03		
Comment	: Est Rev:A New Issue 07-07-04 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	Saddle Billet

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Issue material from stock: 7075-T7351 QQ-A-250/12
Cut Size 2.0 x 6.25 X 6.00
Grain Along Long 6.00 Length
Batch No: 1334872 08/09/09 (2)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
5-Deburr 08/09/09 (2)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet 08/09/10 (2)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET

Comment: INSPECT ALL DIM TO DIM SHEET 08/09/10 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:26:14 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 41726 **Part Number:** D29332UP

Job Number:

Seq. #:	Machine Or Operation:	Description :	
5.0	QC8	SECOND CHECK	
	Comment: SECOND CHECK	DJP 08/09/10 (2)	
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	2x
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	MH 08/09/10	
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
	Comment: INSPECT POWDER COAT	AS 08-09-10	X2
8.0	PACKAGING 1	PACKAGING RESOURCE #1	2x
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 4414	8/9/11	SO
9.0	QC21	FINAL INSPECTION/W/O RELEASE	
	Comment: FINAL INSPECTION/W/O RELEASE		08/09/11

Job Completion

U 08.09.11

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41726
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

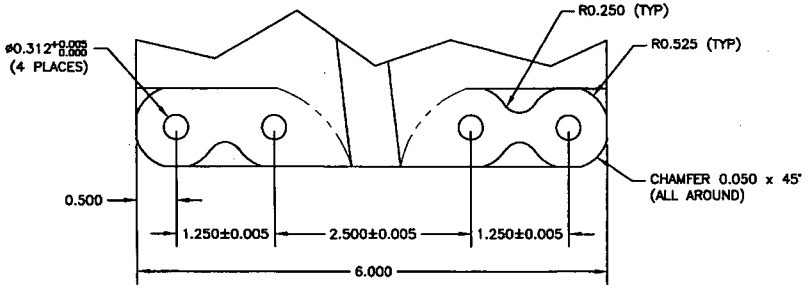
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.128	.128				
B	0.100	0.140		.127	.125				
C	0.100	0.140		.130	.128				
D	0.210	0.230		.223	.223				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.575				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.259	.259				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.239	.239				
N	0.100	0.140		.111	.111				
O	0.540	0.560		.550	.550				
P	0.490	0.510		.504	.504				
Q	3.715	3.725		3.717	3.717				
R	2.470	2.510		2.490	2.490				
S	0.240	0.270		.255	.254				
T	0.100	0.180		.135	.135				
U	1.625	1.635		1.629	1.629				
V	1.362	1.372		1.366	1.366				
W	0.316	0.321		.326	.321				
X	1.125	1.145		1.135	1.136				
Y	1.565	1.585	DT8695 A/B	1.574	1.575				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

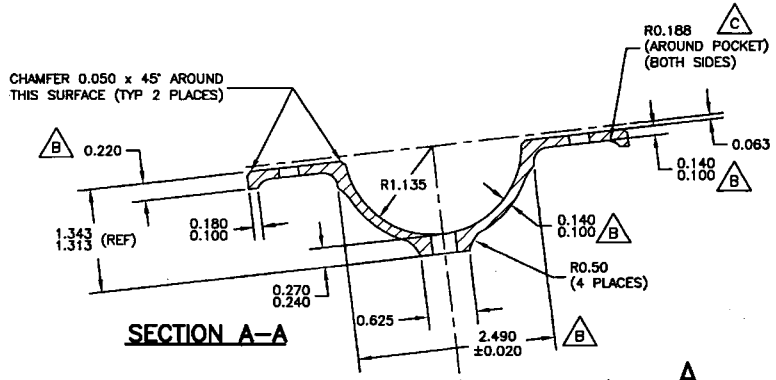
Measured by:	
Date:	08/09/10

Audited by	DP
Date:	08/09/10

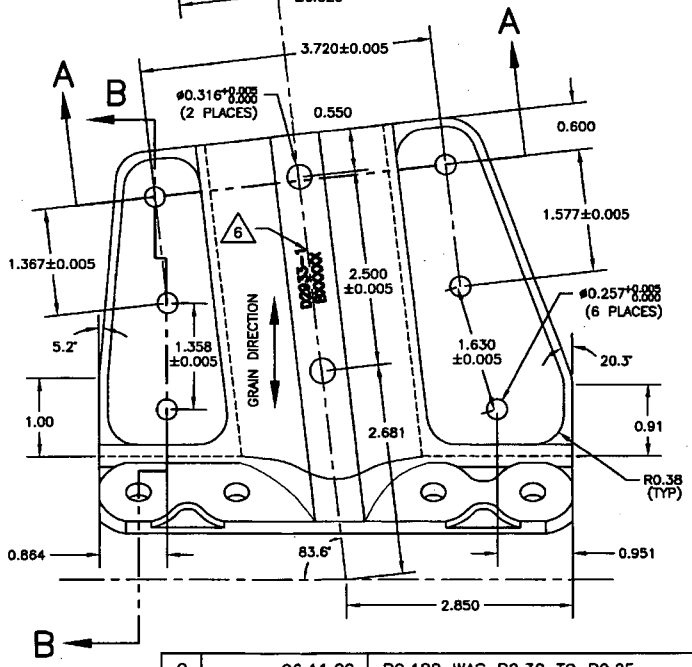
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

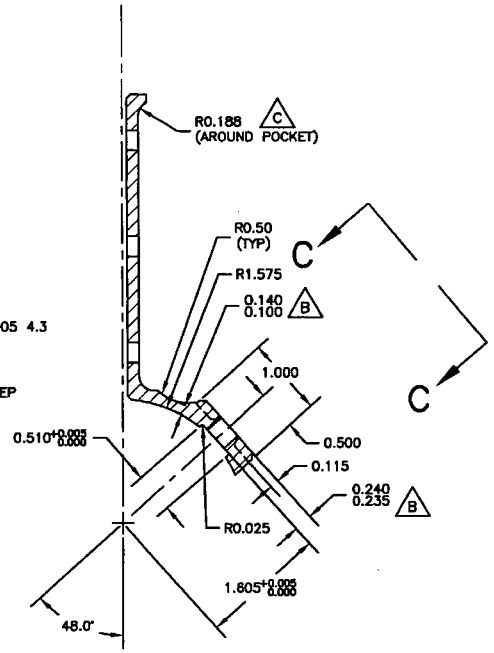


VIEW C–C



SECTION A–A





SECTION B–B

D2933–1 LH SADDLE (SHOWN)
D2933–2 RH SADDLE (OPPOSITE)

NOTES:
1) MATERIAL: ALUMINUM 7075–T7351 (QQ–A–250/12)
(MAKE FROM D6101–001 SADDLE BILLET, 7075)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES
6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

RELEASED
07.02.12

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 117936

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED	APPROVED	DRAWING NO. D2933	REV. C
DATE 06.11.09		TITLE SADDLE INSIDE	SCALE 2:3

SHEET 1 OF 1